



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA6A-200
Job Sheet 169655



Part No: SWA6A-200

Job Qty: 10 ea

Part Name: Upper End



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/18/17

Job Tracking No:

Due Date: 12/29/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG SWA6A-200 Rev8 IPP Rev A 17.11.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	12/28/17	12/28/17	0.00	0.00	Start Up Machining-3		
100	Bandsaw	10 pcs	12/28/17	12/28/17	0.00	1.00	Bandsaw1		
110	Mori Seiki	10 pcs	12/28/17	12/28/17	0.00	10.00	MORI NLX		
120	QC	10 pcs	12/28/17	12/28/17	0.00	0.00	QC2		
122	Mori Seiki	10 pcs	12/29/17	12/29/17	0.00	10.00	MORI NV5000-1		
124	QC	10 pcs	12/29/17	12/29/17	0.00	0.00	QC2 Machining-3		
130	QC	10 pcs	12/29/17	12/29/17	0.00	0.00	QC8		
140	Packaging	10 pcs	12/29/17	12/29/17	0.00	0.00	Packaging3	FEB 08 2018	
150	QC21-SA	10 Ea	12/29/17	12/29/17	0.00	0.00	QC21		

Part Op 100 - Cut Blanks to 6.16"

Descriptions: 110 - 1-Machine as per DWG. FB705 FOLIO REV: _____ DWG REV: _____ 2-Debur***Machine

engrave S/N number and machine engrave UP arrow***

122 - 1-Machine as per DWG. FB705 FOLIO REV: _____ DWG REV: _____ 2-Debur

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M17-4-H1150-R3.000	5	0	0	0

Part Specifications

Specifications could not be found.

Plex 1/3/18 11:58 AM Dart.lajeunesse.marie

DART
AEROSPACE
S032403

Dart Aerospace Ltd.

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Upper End

PART NO: SWA6A-200

Original Serial #: S032403

Revision:

Operation: Start up Operation 01/15/18

Change No:

Job No: 169655

DART AEROSPACE LTD		Work Order:	16965T
Description: upper End		Part Number:	
Inspection Dwg: SWA6A-200 Rev: 8		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.890	±.015/-0.000	.898	/		Mic LPO4	
.04 x 45°	1/2 .010 x .5°	.035 x 45°	/		VERN LPO6	
R.031	1/2 .005	.031	/		Rad gage	
.04 x 45°	1/2 .01 x .5°	.04 x 45°	/		vern LPO8	
.07 x 45°	1/2 .01 x .5°	.065 x 45°	/		↓	
1.328	±.000 / -0.005	1.3265	/		Mic LPO2	
6.038	1/2 .005	6.038	/		Height gage	
1.030	1/2 .005	1.030	/		↓	
Ø2.320	1/2 .005	2.320	/		vern LPO8	
Ø2.05	1/2 .01	2.050	/		↓	
R.220	1/2 .005	.219	/		↓	
.890	1/2 .005	.890	/		↓	
1.14	±.000/-0.02	1.132	/		↓	
R.13	1/2 .01	.125	/		Rad gage	
Ø.32-2B x .25	GO - NO GO	GO	/		GO - NO GO gage	
.04 x 45°	1/2 .01 x .5°	.040 x 45°	/		vern LPO8	
Ø.500 x 1.16	1/2 .005 x 1/2 .01	.504	/		↓	
2.21	1/2 .01	2.215	/		Height gage	
2.45	1/2 .01	2.455	/		↓	
2.94	1/2 .01	2.940	/		↓	
.820	1/2 .005	.819	/		vern LPO8	
.58 x 45°	1/2 .01 x .5°	.580 x 45°	/		↓	
R.13	1/2 .01	.125	/		↓	
.07 x 45°	1/2 .01 x .5°	.07 x 45°	/		↓	
.04 x 45°	1/2 .01 x .5°	.04 x 45°	/		↓	
Ø2.560	1/2 .001	2.560	/		Mic LPO3	
Ø1.910	1/2 .005	1.910	/		1/2 Mic LPO5	
.414	1/2 .005	.414	/		vern LPO9	
3.348	1/2 .005	3.348	/		↓	
R.07	1/2 .01	.062	/		Rad gage	
3-16 UN-2A	Maj 2.9936 1/2 .0047	2.994	/		Mic LPO3	
DOW WØ.04	3.020 1/2 .0028	2.021	/		Mic 104-134	

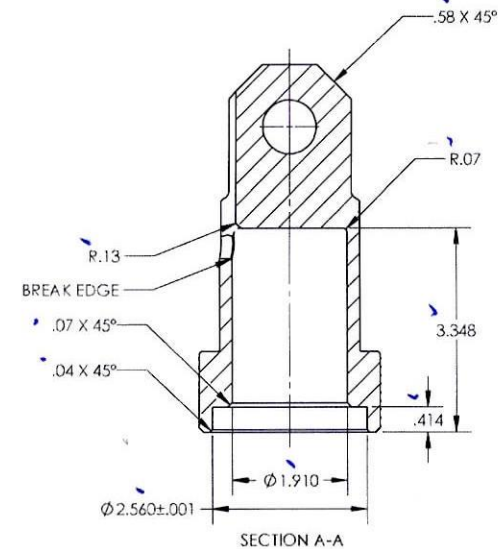
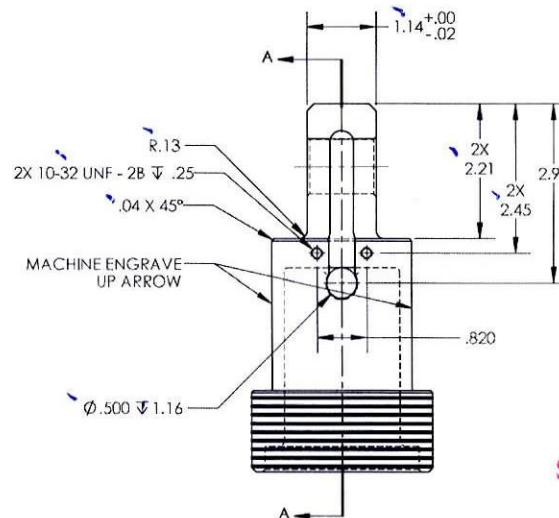
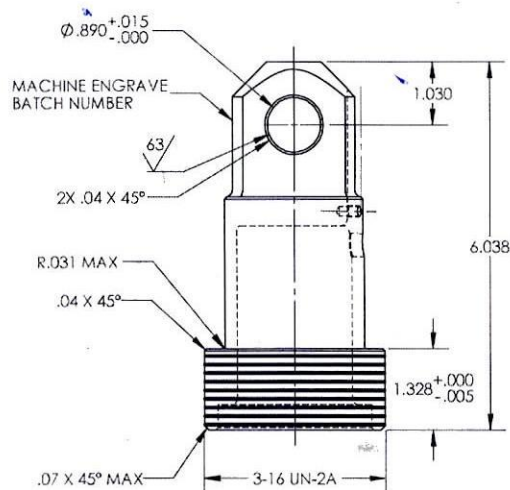
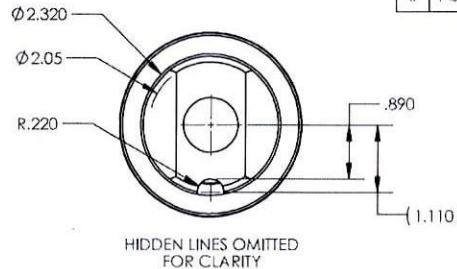
Measured by: <i>[Signature]</i>	Checked by: <i>[Signature]</i>	QC Inspector:
Date: 18-01-17	Date: 18-2-8	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		AS DRAWN BY CANAM.	11/4/2014	JAG	
5	14-0207	CHD CHAMFER ON Ø .890 HOLE WAS 2X .03 X 45° & 2X .04 X 45°, CHD DIA WAS Ø2.06 & Ø2.05.	11/4/2014	RJC	JAG
6	15-0092	ADDED MATERIAL H1075.	4/22/2015	RJC	JAG
7	15-0271	ADDED UP ARROW NOTE, CHD DIMS WAS 1.14 ± .00 - .02, WAS 2.21 & 2X 2.21. DELETED DIMS Ø.90, Ø13/16, P.07. ADDED BREAK EDGE NOTE, CHD TOLERANCE ON NON-CIRCULAR DIMENSIONS.	9/22/2015	OPD	JAG
8	17-0244	UPDATED TO NEW STANDARDS, CHD DIM WAS 9.07 & R 1.3, WAS 2X 10-32 UNF 2.25 & 2X 10-32 UNF 2.25. ADDED NOTE MACHINE ENGRAVE BATCH NUMBER.	3/17/2017	SM	JAG



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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 169554 MUG
17-12-13

ASSY QTY	ASSY QTY	REV	Part #	UNIT QTY	Description	Material	S/O INFORMATION OR SPECIFICATIONS
			SWA6A-200	1	UPPER END	SS 17-4 H1150, H1075	

DART AEROSPACE	
TITLE UPPER END	
DWG NO. SWA6A-200	REV 8
MATERIAL: SS 17-4 H1150, H1075	
TREAT: .XXX ± .005 FRACTIONS ± 1/8	
FINISH: .XX ± .01 ANGLES ± 5°	
SPEC: .X ± .1 SURFACES ± 12%	
DRAWN BY: CANAM	
CHECKED: DD 03/17/2017	
OPPS APPR: AA 03/20/2017	
QA APPR: JL 03/29/2017	
APPROVED: JAG 04/03/2017	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
1. BREAK ALL SHARP EDGES .015 X 45° OR .015X	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
SCALE: 1:2	DATE: 1/31/2002
SHEET 1 OF 1	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					